

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 1 158 068 A1

(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
28.11.2001 Bulletin 2001/48

(51) Int Cl.7: **C22F 1/04, C22F 1/053,**
C22C 21/10

(21) Application number: 01420119.8

(22) Date of filing: 21.05.2001

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE TR
Designated Extension States:
AL LT LV MK RO SI

(72) Inventor: **Warner, Timothy**
38340 Voreppe (FR)

(74) Representative: **Mougeot, Jean-Claude et al**
PECHNEY
Immeuble "SIS"
217, cours Lafayette
69451 Lyon Cedex 06 (FR)

(30) Priority: 24.05.2000 US 206775 P

(71) Applicant: **Pechiney Rhenalu**
75116 Paris (FR)

(54) **Thick products made of heat-treatable aluminum alloy with improved toughness and process for manufacturing these products**

(57) The object of the invention is a rolled, forged or extruded aluminum alloy product more than 12 mm thick, heat treated by solutionizing, quenching and artificial aging, with a microstructure characterized by the following parameters:

- the fraction of recrystallized grains measured between one-quarter thickness and mid-thickness of

the final wrought product is smaller than 35% by volume;

- the characteristic intercept distance between recrystallized areas is greater than 250 μm , preferably greater than 300 μm and most preferably greater than 350 μm .

EP 1 158 068 A1**BEST AVAILABLE COPY**

EP 1 158 068 A1

Description**Field of the Invention**

- 5 [0001] The invention relates to heat-treatable aluminum alloy products in the 2000, 4000, 6000 or 7000 series according to the Aluminum Association designation system, of thickness greater than 12 mm, and a process for manufacturing these products by casting, hot transformation, solution heat treating, quenching and aging. These products may be plates or rolled plates, forged blocks or extruded sections. For products that have a shape other than a parallelepiped shape, the thickness of the product means the maximum quenching thickness, in other words the maximum value for all points within the product of twice the distance to be passed through perpendicular to the nearest surface in contact with the quenching medium.

Description of the Related Art

- 15 [0002] Aluminum alloy products in the 2000 or 7000 series are used particularly for aeronautical construction, and in the heat treated temper. Such applications require a set of properties that are sometimes mutually contradictory, such as:

- 20 - a high mechanical strength in order to limit the weight of the manufactured part,
- sufficient toughness to provide adequate residual strength of a damaged structure,
- good resistance to fatigue (crack propagation rate of pre-cracked specimens, and time to failure of notched and unnotched specimens) caused by vibrations and alternating stresses coming from successive takeoffs and landings,
- 25 - sufficient resistance to the different types of corrosion, and particularly stress corrosion and exfoliation corrosion.

[0003] Therefore, it is essential that an improvement in one property does not take place to the detriment of the other properties. For example, it is well known that the toughness of rolled products made of a given 2000 or 7000 alloy in general reduces when the yield strength increases.

- 30 [0004] Much work has been done to improve the strength-toughness balance of 7000 and 2000 alloys, both on the chemical composition of the alloy, and on its microstructure or its manufacturing procedure. For several decades, the emphasis has been placed on controlling the number, type and morphology of the various intermetallic phases that form during casting or during mechanical and heat treatments.

- 35 [0005] The article by J.T. STALEY "Microstructure and Toughness of High-Strength Aluminum Alloys" published in "Properties related to Fracture Toughness", ASTM Special Technical Publication 605, 1976, pp. 71-103, lists ten possible ways of increasing the toughness of aluminum alloys. This information has guided a great deal of subsequent research in this field. Concerning the chemical composition, research has been carried out on major additive elements (Zn, Mg, Cu) and on minor additives or impurities (Fe and Si in particular).

- 40 [0006] Thus, US patent 3,762,916 to Olin Corp. recommends the addition of 0.05 to 0.4% of zirconium and 0.005 to 0.05% of boron, in order to improve the toughness of forged parts made of 7000 alloy. It states that high contents of titanium should be avoided, since they lead to intermetallic phases that reduce the toughness. The single example of a high content of titanium given in the patent is 0.49%.

- 45 [0007] Report AD/A-002876 by A.R. Rosenfield et al. "Research on Synthesis of High Strength Aluminum Alloys. Part 1. "The Relation between Precipitate Microstructure and Mechanical Properties in Aluminum Alloys", December 1974, prepared for the Air Force Materials Laboratory, studies the influence of the microstructure on the toughness and resistance to fatigue of 7075 alloy. It states that the dominant factor is the grain size of the transformed and treated product, and for sheet (1.6 mm thick) in the largely recrystallized state, the critical stress intensity factor K_{IC} varies as a function of the inverse of the square root of the grain size.

[0008] Patent EP 0473122 by Alcoa states that for AlCuMg alloys, the fact of obtaining a large grain unacceptably reduces some usage properties and particularly the toughness, formability and resistance to corrosion.

- 50 [0009] Therefore, the above comments should guide the metallurgist towards a fine structure for the product, and consequently a fine structure at the casting stage, particularly for microstructures with little recrystallization that retain some features, and in particular dimensional scale, of the cast structure after transformation and heat treatment.

Summary of the Invention

55

[0010] The inventors found that for thick products with an only slightly recrystallized microstructure, a high as-cast grain size (that those skilled in the art would normally tend to avoid) could lead to a specific microstructure of the transformed and heat treated product that has a beneficial effect on the toughness, with no reduction in strength or

EP 1 158 068 A1

other properties.

[0011] The object of the invention is a rolled, forged or extruded aluminum alloy product more than 12 mm thick, heat treated by solutionizing, quenching and artificial aging, with a microstructure characterized by the following parameters:

- the fraction of recrystallized grains measured between one-quarter thickness and mid-thickness of the final wrought product is smaller than 35% by volume;
- the characteristic intercept distance between recrystallized areas is greater than 250 μm , preferably greater than 300 μm and most preferably greater than 350 μm .

[0012] In a preferred embodiment of the invention, the alloy is an AlZnMgCu alloy with the following composition (% by weight):

Zn : 4-10 Mg : 1-4 Cu : 1-3.5 Cr < 0.3 Zr < 0.3 Si < 0.5 Fe < 0.5

other elements < 0.05 each and < 0.15 total, the remainder being aluminum,

[0013] In another preferred embodiment, titanium is maintained between 0.01% by weight and 0.03% by weight, and boron between 1 and 10 $\mu\text{g/g}$.

[0014] Another object of the invention is a process for manufacturing such a product comprising:

- casting the alloy in the form of a rolling, forging or extrusion ingot, such that the as-cast grain size is kept between 300 and 800 μm ,
- homogenization at a temperature greater than 430°C and preferentially greater than 450°C for more than 3 hours, and preferentially more than 6 hours, or even more than 12 hours,
- hot transformation at a controlled temperature to obtain a fraction of recrystallized grains measured between the quarter and half thickness of less than 35% by volume,
- solutionizing at a temperature between 450°C and 490°C,
- quenching,
- possibly stress relaxation by controlled deformation (tension or compression),
- artificial aging.

Brief Description of the Drawings

[0015]

Figure 1 shows, for AA7050 plates submitted to low and fast quenching according to Example 1, the relation between the toughness and the as-cast grain size.

Figure 2 is an illustration of toughness improvements for the invention plates C and D described in Example 2 with respect to prior art plates A and B.

Figure 3 is a graphical representation of the relationship between the fracture toughness and the average intercept distances as mentioned in Table 5 of Example 3.

Figure 4 is a schematic illustration of the approach used to quantify the characteristic intercept distance between recrystallized zones for products according Examples 1 and 3.

Figure 5 is a comparison of microstructures of product numbers 4 (prior art, micrograph a) and 5 (invention, micrograph b) from example 1, obtained from samples taken in L-ST plane, treated with chromic etching, with a magnification of x 25. The darker areas correspond to unrecrystallized grains, the light areas to recrystallized grains.

Detailed Description of the Invention

[0016] The composition of major elements in the alloy may be the same as the composition of all alloys usually used in aeronautical construction. Iron and silicon are preferably kept below 0.15% to prevent the formation of intermetallic compounds that reduce toughness. For AlZnMgCu alloys, zirconium is preferable to chromium or manganese as an

EP 1 158 088 A1

anti-recrystallizing agent since it is less sensitive to quenching and is therefore better for toughness. For thicker products, the content must be at least 0.05% if it is to have any effect on recrystallization, and shall be less than 0.18% Zr, or more preferably less than 0.13% Zr, in order to avoid sensitivity to casting problems.

5 [0017] The concentrations of titanium and boron in the alloy depend on the grain refining method employed. In general grain refining approaches are characterized by the use of nucleant particles that are present in the liquid at the moment of solidification (e.g. TiB₂, TiC, particles) and by the use of an element restricting grain growth (e.g. Ti). If an AlTiB master alloy is used for refining the grain during casting, the most frequently used is AT5B alloy with about 5% of Ti and 1% of B, and AT3B alloy with 3% of Ti and 1% of B. Grain refinement also depends on the nature of the raw materials in the melting bed, the recycled metal, particularly production scrap, leading to an increase in the content of 10 Ti and B. In a preferred embodiment of this invention, this content should remain between 0.01% and 0.03% for Ti and between 1 µg/g and 10 µg/g for B.

[0018] The grain is refined by the formation of dispersed particles of TiB₂ that act as nucleants for the fine crystallization of the alloy during solidification. The grain size during casting does not depend solely on the Ti and B contents related to the composition and the content of refining agent introduced into the liquid metal and the nature of the melting 15 bed, but on many other factors such as the method of introducing the refining agent, its dispersion in the liquid metal, the other elements present in the alloy which may have growth restricting effects (e.g. Zn, Cu), or solidification conditions, for example such as cooling rate.

[0019] The as-cast grain size is measured on a polished sample observed between crossed polars which has undergone a Barker's etch. The intercept method described in ASTM E 1382 is used.

20 [0020] The process according to the invention comprises casting a product (e.g. a billet or an ingot) in which the as-cast grain size is controlled at between 300 and 800 µm, whereas the normal as-cast grain size for alloys of this type is between 100 and 250 µm. The as-cast grain size must be kept below 800 µm to prevent difficulties with casting and a reduction in the elongation properties and the resistance to stress corrosion.

25 [0021] The cast ingots are homogenized at a temperature greater than 430°C and more preferentially greater than 450°C or even 470°C, and are then hot deformed by rolling, forging or extrusion. The temperature of this transformation must be sufficiently high to limit recrystallization. The recrystallization rate, measured in the part between one quarter thickness and mid-thickness of the final product, must be kept below 35%. It is measured by image analysis on micrographs, since the surface fractions of recrystallized grains can be seen in a light color on the dark unrecrystallized matrix. After deformation, the products are solution heat treated at a temperature between 450°C and 500°C, and are 30 then quenched, usually in water, by immersion or by fine spraying, possibly followed by stress relaxation by controlled tension or compression, and finally annealed.

[0022] The microstructure of wrought products according to the invention is different from the microstructure of wrought products according to prior art obtained from ingots with a typical as-cast grain size of less than 250 µm. The wrought products have a less recrystallized structure. The recrystallized areas form a network of a dimension related 35 by a geometrical transformation to the size of the original as-cast grains. For example, a rolling reduction by a factor of two of a spherical cast grain of diameter a will generate a largely unrecrystallized grain whose geometry can be approximately characterized by an ellipsoid of axes $2a$ (L direction), $a/2$ (ST direction), a (LT direction). The periphery of such a grain consists of an incomplete necklace of recrystallized grains. Intermetallic precipitates are observed at the heart of recrystallized areas, and probably act as nucleants for partial recrystallization. The distribution of these 40 precipitates is more homogenous when the as-cast grain size is large.

[0023] It has been found that this microstructure of the wrought products has an influence on the product failure mode. Fractographic observations show that the failure mode for products according to the invention is principally transgranular, in particular for the T-L and L-T directions, whereas it is predominantly intergranular for thick products according to prior art. It could be assumed that this difference between failure modes is the cause of the significant 45 improvement in the toughness, without affecting the mechanical strength or other physical properties necessary for aeronautical construction.

[0024] The products according to the invention can be used advantageously as thick plates for airframe structures, such as spars and ribs or wing skin plates. They can also be used as extrusions for airframe structures, such as stringers in general, and particularly wing stringers. They can also be used as forged parts for airframe structures. 50 However, the applications of the products of the present invention are not limited to the aeronautical field.

Examples

Example 1

55

[0025] Ingots of cross section 500 mm x 1600 mm made of AA7050 alloy with the composition given in table 1 were cast:

EP 1 158 068 A1

Table 1

Chemical composition of alloys									
No	Zn %	Mg %	Cu %	Si %	Fe %	Zr %	Ti $\mu\text{g/g}$	B $\mu\text{g/g}$	Refinement kg/t
1	6.03	1.99	2.12	0.027	0.06	0.11	60	5.3	0.5
2	6.08	2.10	2.11	0.025	0.06	0.11	152	2.1	0.5
3	6.10	2.12	2.22	0.028	0.06	0.11	315	2.0	0.1
4	6.10	2.12	2.22	0.026	0.06	0.11	335	5.1	0.5
5	6.22	2.07	2.17	0.027	0.06	0.11	101	2.0	0.5
6	6.17	2.05	2.22	0.029	0.06	0.11	140	5.0	0.5
7	5.96	2.01	2.17	0.030	0.06	0.08	123	3.3	0.1
8	5.99	2.08	2.20	0.026	0.06	0.11	189	2.0	0.1

[0026] Refining was done using AT5B rod, except for casting 6 which was refined with AT3B rod.

[0027] Samples were taken from the as-cast ingots at a quarter of the thickness and a third of the width for measuring the grain size, and test pieces were taken from the same location and were homogenized at 478°C for 20 h, with a heat-up in 12 h. The test pieces were hot worked at 430°C. They were quenched in water, either at 100°C at a cooling rate of 4.5°C/s to simulate industrial quenching of thick plates, or at 20°C, and were then solution heat treated for 3 h at 478°C and stress relieved by compression in the ST direction with 1.5% deformation. They were then artificially aged in two steps of 6 h at 120°C and then 21 h at 165°C. Two tensile test pieces in the TL direction and two toughness test pieces with B = 12.7 mm (so-called Short Bar Specimens for the determination of K_{ab} , as described in Metals Handbook, 9th edition, Vol 8 "Mechanical Testing", p. 471, published by the American Society for Metals, Metals Park, Ohio), in the T-L direction, were taken from the deformed part of each test piece. The result of the various measurements is given in table 2.

Table 2

Properties of test pieces					
No	As-cast grain size μm	TYS slow quenching [MPa] (NOTE 1)	K_{ab} slow quenching [MPa $\sqrt{\text{m}}$] (NOTE 1)	TYS fast quenching [MPa] (NOTE 2)	K_{ab} fast quenching [MPa $\sqrt{\text{m}}$] (NOTE 2)
1	600	435	32.8	482	43.6
2	250	434	26.0	478	34.3
3	240	447	25.8	483	33.6
4	150	447	23.0	482	33.2
5	350	436	27.7	476	35.5
6	260	440	25.3	472	35.8
7	260	444	26.4	475	35.2
8	270	449	28.7	475	35.2
NOTE 1 : refers to mechanical properties measured at room temperature on test pieces quenched in boiling water.					
NOTE 2 : refers to mechanical properties measured at room temperature on test pieces quenched in water at 20 °C.					

[0028] The toughness results as a function of the grain size are shown in fig. 1. There is a clearly defined correlation between these values. It is also clear that there is no correlation of tensile yield strength with as cast grain size, and thus the identification of a mean of improving toughness of a given alloy composition with no loss in strength.

EP 1 158 068 A1

Example 2:

[0029] Two industrial-scale casts of ingots of dimension 500 mm (ST) x 1600 mm (LT) x 3000 mm (L) of 7050 alloy were performed: the first corresponding to a control specimen, the second to a composition according to the present invention. These casts were practically identical except for the refining practices, which were in both cases by addition of 0.5 kg/t of AT6B rod, but for plates A and B into an alloy containing a total of 0.0326% Ti, plates C and D a total of 0.0138% Ti.

[0030] From each of these two casts, two ingots were selected for transformation to 152 mm (6") employing an identical standard plate fabrication route, including homogenization, pre-heating, hot rolling, solution heat treatment and cold water quenching, stretching, and aging to the T7451 condition.

[0031] The compositions and mechanical properties of plates A and B (prior art) and C and D (invention) are presented as tables 3 and 4 respectively. Plain strain fracture toughness was determined according to ASTM E 399.

[0032] All the plates show practically identical strengths but significant differences in fracture toughness (see also figure 2). Improvements in fracture toughness are observed in all three testing directions. The most significant improvements are observed in the S-L and T-L directions (respectively + 4.5 and + 4.3 MPa√m on average), but a significant improvement is also observed in the L-T direction (+2.6 MPa√m on average).

Table 3

Compositions of alloys for example 2.

Plates	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Zr	Pb
A and B	0.039	0.070	2.16	0.008	2.04	0.007	0.004	6.23	0.033	0.110	0.001
C and D	0.033	0.060	2.10	0.006	2.07	0.004	0.005	6.10	0.014	0.105	0.001

Table 4

Properties of plates for example 2.

Properties of plates for example 2.						
Tensile testing					Toughness testing	
Plate	Orientation	UTS [MPa]	TYS [MPa]	Elongation [%]	Orientation	K _{IC} [MPa√m]
A (prior art)	L	505	441	9.2	L-T	28.6
	LT	511	433	7.7	T-L	25.1
	ST	492	412	7.6	S-L	28.0
B (prior art)	L	513	452	8.6	L-T	29.4
	LT	514	436	7.0	T-L	24.3
	ST	500	424	6.6	S-L	27.3
C (invention)	L	500	437	9.9	L-T	32.6
	LT	508	429	7.8	T-L	29.3
	ST	490	414	7.1	S-L	31.6
D (invention)	L	502	437	9.6	L-T	30.7
	LT	510	433	6.7	T-L	28.6
	ST	489	407	7.0	S-L	30.7

Example 3: Image analysis of recrystallized structures

[0033] The distribution of recrystallized zones in wrought products according to the present invention is characteristically different from that in classical 7050 thick products. As can be observed in figure 5 (obtained from test piece number 5 in Table 2), the characteristic distance between recrystallized regions of the invention product is significantly larger than that of prior art (test piece number 4 in Table 2). This can be quantified by image analysis of etched L-ST micrographs. Any etch that generates contrast in the unrecrystallized regions can be exploited (e.g. chromic etch, Keller's etch). The approach used is described schematically in figure 4. For lines randomly placed in the L-direction

EP 1 158 068 A1

of a micrograph obtained in the L-ST plane, individual intercept distances between recrystallized regions are measured (see intercept 1, intercept 2, intercept 3, intercept 4 in figure 4). A stable and representative mean of such intercepts is obtained for several thousand measurements, and this mean is taken to be the average intercept distance.

[0034] Typical average intercept distances are presented as table 5 for products considered in example 1. A graphical representation of these results is presented as figure 3. It is clear that this parameter is well correlated to fracture toughness. Higher values of this average intercept give higher T-L toughnesses. Values greater than 250 μm , or preferably 300 or even 350 μm , are characteristic of the improved product.

[0035] It is clear that greater hot reductions will tend to elongate the structure to a greater extent in the L direction. However, the higher recrystallization rates typical of greater hot reductions will tend to compensate for the increased stretching of the microstructure in the L direction. It appears that in general, for plate thicker than approximately 100 mm, intercept distances greater than 250 μm , or preferably 300 or even 350 μm , will give improved toughness compared with conventional plate.

Table 5

Typical average intercept distances for the products considered in example 1.		
Product no.	Average intercept distance [μm]	K_{ch} values
1 (invention)	384	32.6
2 (prior art)	207	26
4 (prior art)	160	23
5 (invention)	343	27.7
6 (prior art)	222	25.3
7 (prior art)	200	26.4
8 (invention)	253	28.7

Claims

1. Rolled, forged or extruded aluminum alloy product more than 12 mm thick, heat treated by solutionizing, quenching and artificial aging, having a fraction of recrystallized grains measured between one-quarter thickness and mid-thickness of the final wrought product smaller than 35% by volume, and a characteristic intercept distance between recrystallized areas greater than 250 μm .
2. The product according to claim 1, wherein the characteristic intercept distance between recrystallized areas is greater than 300 μm .
3. The product according to claim 2, wherein the characteristic intercept distance between recrystallized areas is greater than 350 μm .
4. The product according to claims 1 to 4, characterised in that it is made of an AlZnMgCu alloy with the following composition (weight %):

Zn : 4-10 Mg : 1-4 Cu : 1-3.5 Cr < 0.3 Zr < 0.3 Si < 0.5 Fe < 0.5,

other elements > 0.05 each and < 0.15 total, the remainder being aluminum.

5. The product according to claim 4, wherein the alloy is selected from 7010, 7020, 7040, 7049, 7050, 7055, 7080, 7075, 7149, 7150, 7175, 7349, 7449, 7475.
6. The product according to claims 1 to 5, having a Ti content between 0.01 and 0.03 weight % and a B content between 1 and 10 $\mu\text{g/g}$.
7. The product according to claim 6, having a Ti content between 0.01 and 0.02 weight %.

EP 1 158 068 A1

8. Method for manufacturing a heat-treatable aluminum alloy product comprising:

- casting the alloy in the form of a rolling, forging or extrusion ingot, such that the grain size is kept between 250 μm and 800 μm ,
- homogenization,
- hot transformation at a controlled temperature to obtain a fraction of recrystallized grains measured between the quarter and half thickness of less than 35% by volume,
- solution heat treating,
- quenching,
- possibly stress relaxation by controlled deformation (tension or compression),
- artificial aging.

9. The method according to claim 8, wherein the alloy is an AlZnMgCu alloy with the following composition (weight %):

Zn : 4-10 Mg : 1-4 Cu : 1-3.5 Cr < 0.3 Zr < 0.3 Si < 0.5 Fe < 0.5,

other elements > 0.05 each and < 0.15 total, the remainder being aluminum,

10. The method according to claims 8 or 9, wherein the Ti content is between 0.01 and 0.03 weight % and B between 1 and 10 $\mu\text{g/g}$.

11. The method according to claim 10, wherein the Ti content is between 0.01 and 0.02 weight %.

12. Ingot for rolling, forging or extrusion, made of a heat-treatable aluminum alloy having an as-cast grain size kept between 250 μm and 800 μm , which is suitable for the manufacture of wrought products for aircraft structural members.

13. Ingot according to claim 12, wherein the alloy is an AlZnMgCu alloy with the following composition (% by weight):

Zn : 4-10 Mg : 1-4 Cu : 1-3.5 Cr < 0.3 Zr < 0.3 Si < 0.5 Fe < 0.5 Ti:

0.01-0.03 B : 1-10 ppm, other elements > 0.05 each and 0.15 total, the remainder being aluminum,

14. Ingot according to claim 13, wherein the alloy is selected from the group of 7010, 7020, 7040, 7049, 7050, 7055, 7080, 7075, 7149, 7150, 7175, 7349, 7449, 7475.

15. Structural member for airframe structures, made in a rolled, forged or extruded product according to claim 1.

EP 1 158 068 A1

Figure 1

Toughness as a function of as-cast grain size.

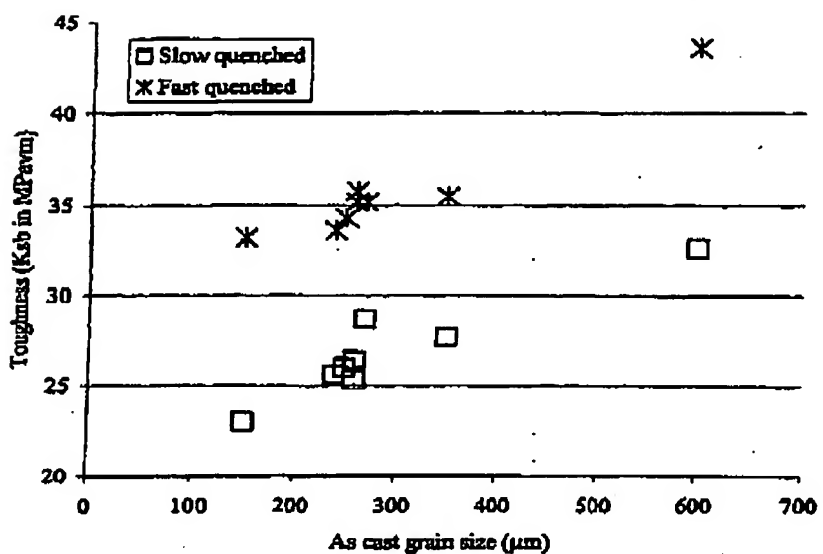
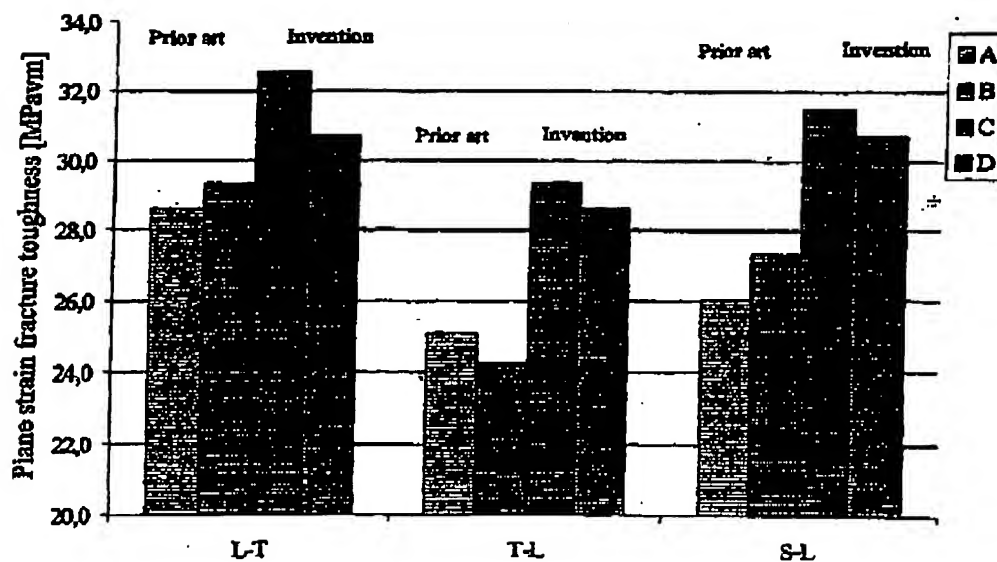
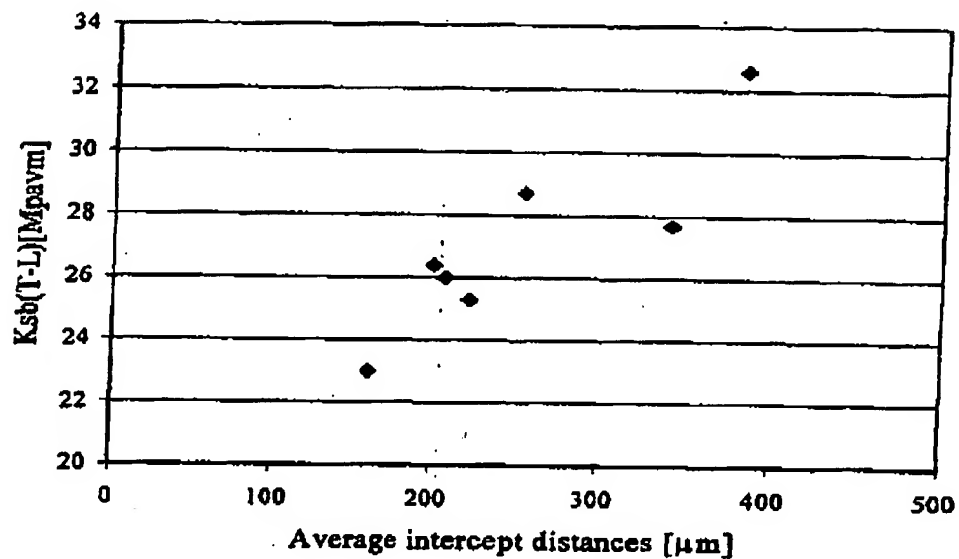
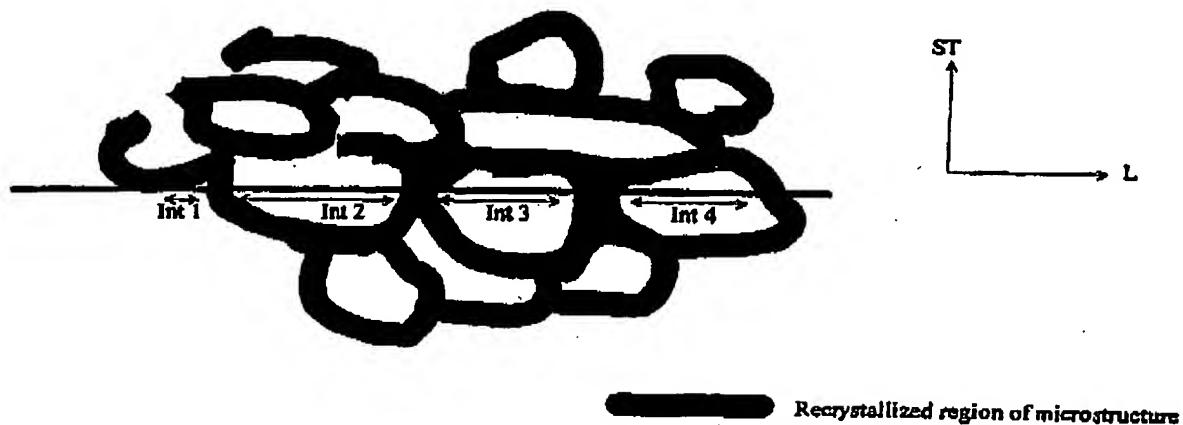
**Figure 2**

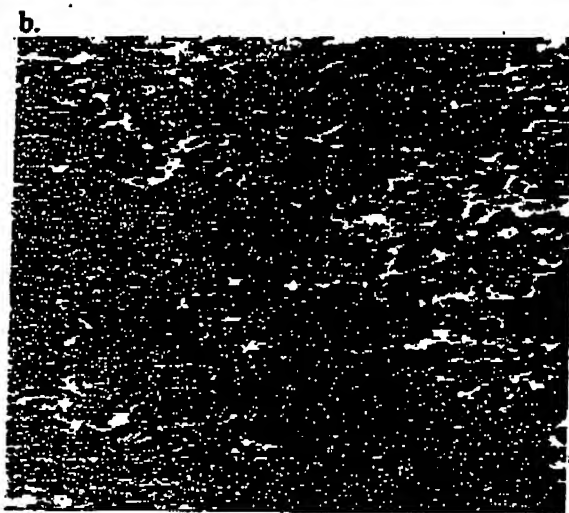
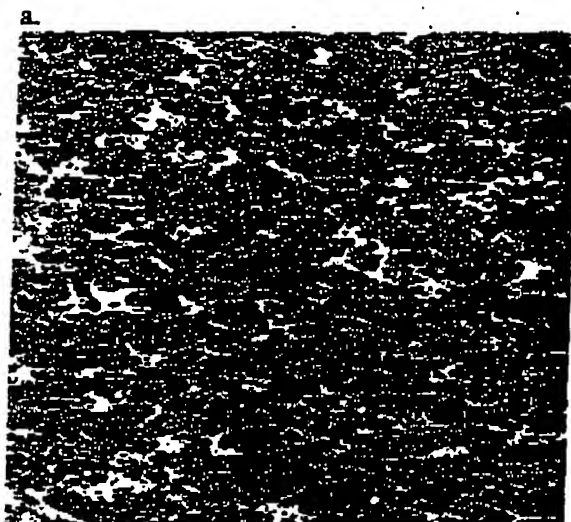
Illustration of toughness improvements for the invention plate with respect to the control specimens.



EP 1 158 068 A1

Figure 3**Relationship between average intercept distances and fracture toughness****Figure 4****Schematic illustration of the approach used to quantify the characteristic intercept distance between recrystallized zones for the products described above.**

EP 1 158 068 A1



EP 1 158 068 A1

European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 01 42 0119

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (InCL.7)
X	PATENT ABSTRACTS OF JAPAN vol. 1999, no. 02, 26 February 1999 (1999-02-26) - & JP 10 298691 A (FURUKAWA ELECTRIC CO LTD; HONDA MOTOR CO LTD), 10 November 1998 (1998-11-10) * abstract *	1-15	C22F1/04 C22F1/053 C22C21/10
A	US 6 027 582 A (VERDIER JEAN-FRANCOIS ET AL) 22 February 2000 (2000-02-22) * claim 1 *	1	
A	PATENT ABSTRACTS OF JAPAN vol. 1997, no. 12, 25 December 1997 (1997-12-25) - & JP 09 209056 A (KOBE STEEL LTD), 12 August 1997 (1997-08-12) * abstract *	1,8,12	
A	EP 0 942 071 A (NIPPON LIGHT METAL CO ; FUJI PHOTO FILM CO LTD (JP)) 15 September 1999 (1999-09-15) * claim 1 *	1,8,12	TECHNICAL FIELDS SEARCHED (InCL.7)
A	PATENT ABSTRACTS OF JAPAN vol. 1999, no. 03, 31 March 1999 (1999-03-31) - & JP 10 317114 A (NIPPON LIGHT METAL CO LTD), 2 December 1998 (1998-12-02) * abstract *	1,8,12	C22F C22C
A	PATENT ABSTRACTS OF JAPAN vol. 2000, no. 05, 14 September 2000 (2000-09-14) - & JP 2000 054051 A (MITSUBISHI ALUM CO LTD; NISSAN MOTOR CO LTD), 22 February 2000 (2000-02-22) * abstract *	1,8,12	
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		28 August 2001	Gregg, N
CATEGORY OF CITED DOCUMENTS X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention E: earlier patent document, but published on or after the filing date D: document cited in the application L: document cited for other reasons A: member of the same patent family, corresponding document			

EPO FORM 1503 03/02 (PAG.1)

EP 1 158 068 A1

European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 01 42 0119

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (INCL.7)
A	PATENT ABSTRACTS OF JAPAN vol. 2000, no. 05, 14 September 2000 (2000-09-14) - & JP 2000 054054 A (NIPPON LIGHT METAL CO LTD), 22 February 2000 (2000-02-22) * abstract *	1,8,12	
A	PATENT ABSTRACTS OF JAPAN vol. 1996, no. 05, 31 May 1996 (1996-05-31) - & JP 08 003675 A (NIPPON LIGHT METAL CO LTD; OTHERS: 01), 9 January 1996 (1996-01-09) * abstract *	1,8,12	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (INCL.7)
Place of search THE HAGUE		Date of completion of the search 28 August 2001	Examiner Gregg, N
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			

EPO FORM 1501 02/95 (P.6/6)

EP 1 158 068 A1

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 01 42 0119

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

28-08-2001

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
JP 10298691 A	10-11-1998	NONE	
US 6027582 A	22-02-2000	FR 2744136 A DE 69700330 D DE 69700330 T DE 876514 T EP 0876514 A JP 2000504068 T CA 2244148 A WO 9727343 A	01-08-1997 19-08-1999 13-01-2000 06-05-1999 11-11-1998 04-04-2000 31-07-1997 31-07-1997
JP 09209056 A	12-08-1997	NONE	
EP 0942071 A	15-09-1999	JP 11256293 A	21-09-1999
JP 10317114 A	02-12-1998	NONE	
JP 2000054051 A	22-02-2000	NONE	
JP 2000054054 A	22-02-2000	NONE	
JP 08003675 4 A		NONE	

EP01354/P0419

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ **BLACK BORDERS**
- ☐ **IMAGE CUT OFF AT TOP, BOTTOM OR SIDES**
- ☐ **FADED TEXT OR DRAWING**
- ☐ **BLURRED OR ILLEGIBLE TEXT OR DRAWING**
- ☐ **SKEWED/SLANTED IMAGES**
- ☐ **COLOR OR BLACK AND WHITE PHOTOGRAPHS**
- ☐ **GRAY SCALE DOCUMENTS**
- ☐ **LINES OR MARKS ON ORIGINAL DOCUMENT**
- ☐ **REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY**
- ☐ **OTHER:** _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.